July-22-13 1:57:01 PM

Item ID: Revision ID:	D4018-041		Accept	*N900	040	100	<b>)*</b> s	etup Sta	i Vi	S1*
Item Name:	Short Basket Lid Assembly (350	)						Sto	P *N	S2*
Start Date:	7/22/13 Start Qty: 1.9	•		Cust Item	ID:					
Required Date:	: 8/05/13 Req'd Qty: 1.6	<sup>00</sup> *1*		<b>Customer:</b>						
Reference:	=									
Approvals:	Process Plan: <u>Mし</u> ブ	Date:/ <i>3-07-72</i>	Tooling:	D	ate:		R	tun Sta	!/	R1*
	QC:	Date:	SPC (Y/N):	<b>D</b>	ate:			Sto	*N	R2*
Sequence ID/ Work Center I	Operation Description	· y	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					***	MY 433 MM 19			
D4018	С			•						
100	Weld per dwg A/R	R S.S. rod Batch: 州いろという	<b>0</b> .00						- Bertanie	
*100* Large Fåb	Large Fab <b>Mem</b> o		0.00	,	·~.		13	- <u>08.2</u>	1	PD
Large Fab	2- wel ***ins 3- tack ***ma	emble ribs, weld as per dwg D40 d hinge (3) and Mounting bracke spect before welding mesh*** a weld mesh on basket as per dwg ake sure to place mesh correctly og mesh***	ts as per dwg D4018 g D4018	te before						
*110	QC9- Inspect visua	ıl per QSI004- Fusion Welds	0.00	٠		1 ,		Ω.	2	<b>918</b>
QC Quality Control	Memo	<b>)</b>	0.00						13	- <u>06-</u> 21

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	100	NFORM	MANCE / UPDATE		QA Closed:	Date:	
					DISPOSITION			AGAINST		PARTMENT/		
Work Orde	r:		• • • • • • • • • • • • • • • • • • • •	<del></del>		,			_	i I		1
Part N	o				Rework Scrap Use-as-is		ı	Skid-tube Crosstube  Machining Small Fab  noforming Finishing		1	Water Jet d. Eng. Coor e/Packaging	Engineering Quality Other
NCR N	0				Work Order Update			Large Fab Composite			Supplier	
Root				Descri	ption of work order update	1	nitial	Action		Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data												
quip/Tooling												
Operator												
Material												
Setup												
Other												
Process	_	1						<i>`</i> '				:
Supplier			,						İ			
Training	_											
Unapproved		1	ļ									
						AUL	T CATE	GORY				
Landin	g Gear			_	General		1	r	_	1		1
-	Bending				Bend	$\vdash$	Grain		1-	Ovalized	. —	Pressure/Forced
	Centre N	ot Conce	ntric to	o/s  _	BOM/Route		Hardwa	†	-	Over/Under	<del> </del>	Temperature/Cure
1	Cracks				Broken/Damaged	_	1	on incomplete	-	Part Incorrec	<b></b>	Weld
1	Crushed/	Crimped		<u> </u>	Burrs		4	ions Incomplete/Unclear	-	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	_	Mainte	enance		Part Moved		
	Heat Trea	at		1	Countersink	1	Mislabe	led	1	Positioned W	/rong	

Misread

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio July-22-13 1:57:01 PM

Item ID: Revision ID: Item Name:	D4018-041 Short Basket	Lid Assembly (350)		Accept	*	N90	<b>೧</b> ೧4೧	100	<b>)</b> *	Setup Star Stop	1 🚺	S1* S2*
Start Date: Required Date Reference:	7/22/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*			Cust Iter Custome					14	
Approvals:		an:		Tooling SPC (Y			Date:		1	Run Star Stoj	1/1	R1* R2*
Sequence ID/ Work Center 1 120 *120* QC Quality Control	ID	Operation Description QC5- Inspect part comple Memo	eteness to step on W/O	Set U Run 0.00	Hours  Share  13 & 2)	Tool III DAS 27 9-89	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	38	Black Sandtex(Ref:4.3.5.  Memo  *** mask sic Start Time: Oven Tempe Finish Time:	les of hinge prior to powd	0.00 0.00 ercoat***				ĺ	ΧÝ	M	L13,	108/20
140 *140* HandFinish Hand Finishing		Install placa	S1005 4.4 Batch // / / / / / / / / / / / / / / / / /	0.00 lk on outside	surface of mesh as	-				Ø	BL.1.	3-8-22

											DQA:	Date:	
NCR: Y	⁄es	/ No				WORK ORDER NON-C	ON	VFORI	MANCE / UPDATE		QA Closed:	Date:	
Work Orde	er:	<del></del>				DISPOSITION			AG	.**	PARTMENT		
Part N	٠ . ١٥٠					Rework Scrap Use-as-is Work Order Update		Thern	Machining Sma	sstube all Fab nishing posite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	1	nitial	Action		Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data						-							
Equip/Tooling		·											
Operator							.						
Material													
Setup			1			2.3c							•
Other						•							
Process													
Supplier													
Training									7				
Unapproved			j										
						F	AUL	T CATE	GORY				
Landi	ng (	Gear				General					_		
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	on Incomplete		Part Incorred	ct 🗍	Weld
	Г	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled

Maintenance

Out of Calibration
Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish Folio Part Moved

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

July-22-13 1:57:01 PM

Item ID: Revision ID:	D4018-041			Accept	*N900	1040	100	)* s	Setup Star	14.	31*
Item Name:	Short Basket	Lid Assembly (350)			·				Sto	» *N.S	32* ·
Start Date:	7/22/13	Start Qty: 1.00	*1*		Cust Item	ID:					
Required Date:	8/05/13	<b>Req'd Qty:</b> 1.00	*1*		<b>Customer:</b>						
Reference:			<u>-</u>								
Approvals:	Process P	lan:	Date:	Tooling:	D	ate:		F	Run Stai	" 7	?1*
	QC:		Date:	SPC_(Y/N):	D	ate:			Sto	° *NF	?2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject	Insp. Stamp
150		QC3- Inspect Part Finish		0.00					ſ	AA 1 /	1
*150*		Memo		0.00				<u>l</u> x	·	JU 136	08/22
Quality Control									•		
160		Identify as per dwg & Sto	ock Location: <b>P403</b> 6	D-041.00	104662						
*160* Packaging Packaging		Мето		0.00	,			/_	\$	bl B	-8-22
	•					,	t				
170		QC21- Final Inspection -	Work Order Release	0.00				$\mathcal{A}$	/		
*17 <b>0</b> *				0.00				97	1 1	11309/24	)
QC Quality Control		Мето		0.00	·			·'V	/	11309/24 · MF (3-	· - 2-
						÷				(3	8.20

										DQA:	Date:	
NCR: Y	es / No	)			WORK ORDER NON-C	100	NFORM	MANCE / UPDATE		QA Closed:	Date:	
144 - ul. Oud					DISPOSITION			AGA	AINST DE	PARTMENT	#.# <u>.</u>	
Work Orde  Part N  NCR N					Rework Scrap Use-as-is Work Order Update		Thern	Machining Smal	stube II Fab shing oosite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	<u> </u>		1	Descri	ption of work order update		nitial	Action		Sign &		
Cause	Date	Step	Qty	1	or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data								-				
Equip/Tooling						ļ						
Operator												
Material			İ									
Setup												
Other											•	
Process												
Supplier												
Training			}									
Unapproved						<u>L</u>					<u>.</u>	
						AUL	T CATE	GORY				
Landi	ng Gear			_	General		•		<b></b>	,	_	1
	Bendir	g			Bend		Grain			Ovalized	<u> </u>	Pressure/Forced
	Centre	Not Conce	ntric to	o/s	BOM/Route		Hardwa	re	<u> </u>	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct	Weld
	Crushe	d/Crimped			Burrs		Instruct	ions Incomplete/Unclear	L	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
l	Heat T	reat			Countersink		Mislabe	eled		Positioned V	Vrong	

Misread

Out of Calibration
Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

## **Picklist Print**

July-22-13 1:57:05 PM

Work Order ID: 104874

\*104874\*

Parent Item:

D4018-041

\*D4018-041\*

Parent Item Name: Short Basket Lid Assembly (350)

**Start Date:** 7/22/13

Required Date: 8/05/13

Page 1

Start Qty: 1.00

Required Qty: 1.00

**Comments:** 

IPP RevA: new issue DD 09.11.30 verified by:EC

IPP Rev:B as

per dwg revA 10.03.15 verified by:EC

IPP Rev:C as per dwg

RevB DD 10.04.16 verified by:EC

IPP Rev:D as per dwg revC DD

	0.08.18 verified b	•	1,1	i kev.D as p	ci dwgieve i	, , , , , , , , , , , , , , , , , , ,						
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per K	Cit Total Qty	Qty Issued	Date Status Issued
D4018-1		Manufactured	No			100	Each	8.0000	2	2		
*D4018-13	<b>k</b>								**	· · · · · · · · · · · · · · · · · · ·		308-16 PD
				Location		Loc C	<u>Oty</u>	Loc Code		4 1 - 6 - 6		
				WA005			8			120703	39 2	)
					72545		5				_	
D4010.2					86016		3		_			
D4018-3		Manufactured	No			100	Each	2.0000	2	2		
*D4018-33	<b>,</b>								**			130416 PD
				Location		Loc C	<u>Otv</u>	Loc Code				
				WA005			2			B101295	[->(D)	
					76380		2				_	
D4016-3		Manufactured	No			100	Each	60.0000	3	3		
*D4016-37	<del>t</del>								**			13.08.16 80

<b>Location</b>	Loc Qty	Loc Code	
WA	40		B104365->(3)
103029	40		
WA004	20.		
101043	12		
102214	8		

											DQA:	Date	:
NCR: Y	/es	/ No				WORK ORDER NON-O	COI	NFORM	ANCE / UPDA	TE	•		
									-		QA Closed:	Date	•
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	-				•	Rework Scrap			<b></b>	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
, aici	•0.				<del></del>	Use-as-is	i		noforming	Finishing		e/Packaging	Other
NCR N	No.		<del> </del>			Work Order Update	]	l .	~ <del>  </del>	Composite		Supplier	
Root					Descri	ption of work order update		Initial	Action	1	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Descript	ion	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling								,					
Operator													
Material									•	•	·		
Setup							١.	. ,		•			
Other		·*							•				
Process							ŀ					٠	
Supplier							1						
Training													
Unapproved													
						F	ΑUI	LT CATE	GORY				
Landi	ng G	iear				General		-		_	•	_	<b>-</b>
	Ш	Bending		•		Bend		Grain		<b></b>	Ovalized		Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/Unc	lear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		
		Heat Trea	it .			Countersink		Mislabe	led		Positioned V	Vrong	_
		Inspection	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset		_ <del>-</del> -			

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

July-22-13 1:57:05 PM

Work Order ID: 104874

\*104874\*

Parent Item:

D4018-041

\*D4018-041\*

Parent Item Name: Short Basket Lid Assembly (350)

**Start Date: 7/22/13** 

Required Date: 8/05/13

Start Qty: 1.00

\*\*

\*\*

Required Qty: 1.00

D4018-5

D4035-043

\*D4018-5\*

Manufactured No

Manufactured

No

100

100

Each

Each

Each

9.0000

6

13-06-16 80

Location Loc Qty Loc Code 897693 -10 WA005 9 100347

D4035-041 \*D4035-041\*

Lid Rib Assembly, Fwd (350 Basket)

Location Loc Qty

WA004

Loc Code

1.0000

8100979 -> W

Manufactured No 103905

98841

100

20.0000 \*\*

B-08-20 PD

13.08.20 PD

Lid Rib Assembly, Aft (350 Basket)

Location Loc Qty Loc Code WA004 13 9 103960 97686 97687 WA005 81202 81452 82988

B102479-> (1)

July-22-13 1:57:05 PM

**Shop Packet Print** 

Page 2

NCR: Ye	es / No				WORK ORDER NON-O	CONFC	DRM	IANCE / UP	PDATE			
										QA Closed:	Date:	
Work Ordei	ŕ:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
					Rework	7 <b> </b>	S	kid-tube	Crosstube	]	Water Jet	Engineering
Part No	0.				Scrap	1	M	lachining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	]   Th	nermo	oforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	0				Work Order Update	]	. L	arge Fab	Composite	]	Supplier	
Root				Descri	ption of work order update	Initia	al .	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data												
quip/Tooling											·	,
Operator .	∴ ,								•			
Material												
Setup				•								
Other												
Process		-		'								
Supplier			ļ							1		
Training									*			
Unapproved				<u> </u>		1						
					F	AULT CA	ATEG	ORY				
Landin	g Gear			<u> </u>	General					•		<b>.</b>
L	Bending				Bend	Gra	ain 🗀		L	Ovalized		Pressure/Forced
L	Centre N	ot Conce	ntric to	o/s	BOM/Route	Har	dware	е		Over/Under	tolerance	Temperature/Cure
	Cracks			· · · L	Broken/Damaged	Insp	oectio	n Incomplete		Part Incorre	ct _	Weld '
	Crushed/	Crimped			Burrs	Inst	ructio	ons Incomplete/	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Ma	inten	ance		Part Moved		
	Heat Trea	at		` [	Countersink	Mis	labele	ed		Positioned V	Vrong	_
Ī	Inspectio	n Strip in	Tube		Cut Too Short	Mis	read			Power Loss/	'Surge	Other
	Ripples ir	n Bend			Drill Holes	Offs	set				•	
ŗ	Torque V	Vaves in I	Extrusio	n 🗀	Drawing	Out	t of Ca	libration				
ľ	Turning S	equence	<b>!</b>		Finish	Out	t of Se	quence				
<u> </u>	Wave/Tw	vist in Tu	be		Folio	Out	tside [	Dimensions				

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

## **Picklist Print**

July-22-13 1:57:05 PM

Work Order ID: 104874

\*104874\*

Parent Item:

D4018-041

\*D4018-041\*

Parent Item Name: Short Basket Lid Assembly (350)

**Start Date:** 7/22/13

\*\*

Required Date: 8/05/13

Start Qty: 1.00

Required Oty: 1.00

13-08-16 1)

D2581

Manufactured

Manufactured

Manufactured

No

No

No

100

Each 115.0000 2

\*D2581\*

Mounting Bracket

	_							
<b>Location</b>	<u>Lo</u>	c Oty	Loc Code					
WA004		115						
1030 <u>76</u>		24			_(2)	_		
(103100)		28						
103952		49						
70766		2						
81253		1						
82506		2				_		
83230		3				_		
85452		2						
87706		2						
99837		2						
	100	Each	0.0000	1	1		•	
				**	Loui	(n = 20)	13-08-20	(19
					D104	999 20	13408-90 4	
	100	Each	56.0000	1	1		• 1	
				**			4.	
				*****		13.08	3-20 ()	

\*D4020-7\* Mesh (350 Basket Short, Lid)

D4021-3

D4020-7

\*D4021-3\*

Data Plate

Location	Loc Qty	Loc Code
WA004	56	
(101346)	46	
00007	0	

D2728-3

Manufactured

80897 82507 140 Each

0.0000

\*\*

												DQA:	Da	te.	
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UP	PDATE		QA Closed:	 Da	te:	
				<u>-</u>	······	DISPOSITION				AGAINST	DE	PARTMENT			
Work Orde	er: _									AGAMOT					, , , , , , , , , , , , , , , , , , , ,
Part I	-					Rework Scrap Use-as-is		Therm	Skid-tube Machining noforming	Crosstube Small Fab Finishing		4	Water Jet d. Eng. Coor. re/Packaging		Engineering Quality Other
NCR I	No				<u>-</u>	Work Order Update	J		Large Fab	Composite		J	Supplier		
Root					Descri	ption of work order update	Ī	nitial	Ad	tion		Sign &			
Cause	1	Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	cription		Date	Verificatio	n	QC Inspector
Doc/Data			,												
Equip/Tooling		•													
Operator															
Material															
Setup			<u> </u>												
Other															
Process	Ш							1	*						
Supplier	Ш			1											
Training	Ш		·												
Unapproved			<u>l</u>	<u> </u>											
							AUL	T CATE	GORY						
Landi	Ť				_	General		1		r		7			<b>.</b>
	-	Bending			<u> </u>	Bend	<u> </u>	Grain				Ovalized			Pressure/Forced
	Centre Not Concentric to O/S Cracks Crushed/Crimped				o/s	BOM/Route		Hardware				Over/Under			Temperature/Cure
					<u> </u>	Broken/Damaged	· –		Inspection Incomplete						Weld
						Burrs		Instructions Incomplete/Unclear				Part Lost/Mi			Wrong Stock Pulled
	Ш	Cuffs			<u> </u>	Contamination	<u> </u>	Mainte				Part Moved			
		Heat Trea			<u> </u>	Countersink	<u></u>	Mislabe				Positioned V	_	_	<b>1</b>
ļ ,		Inspection	-	Tube	·	Cut Too Short	$\vdash$	Misreac	l			Power Loss/	Surge	L	Other
'		Ripples in	Bend		1	Drill Holes	1	Offset							

Out of Calibration
Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

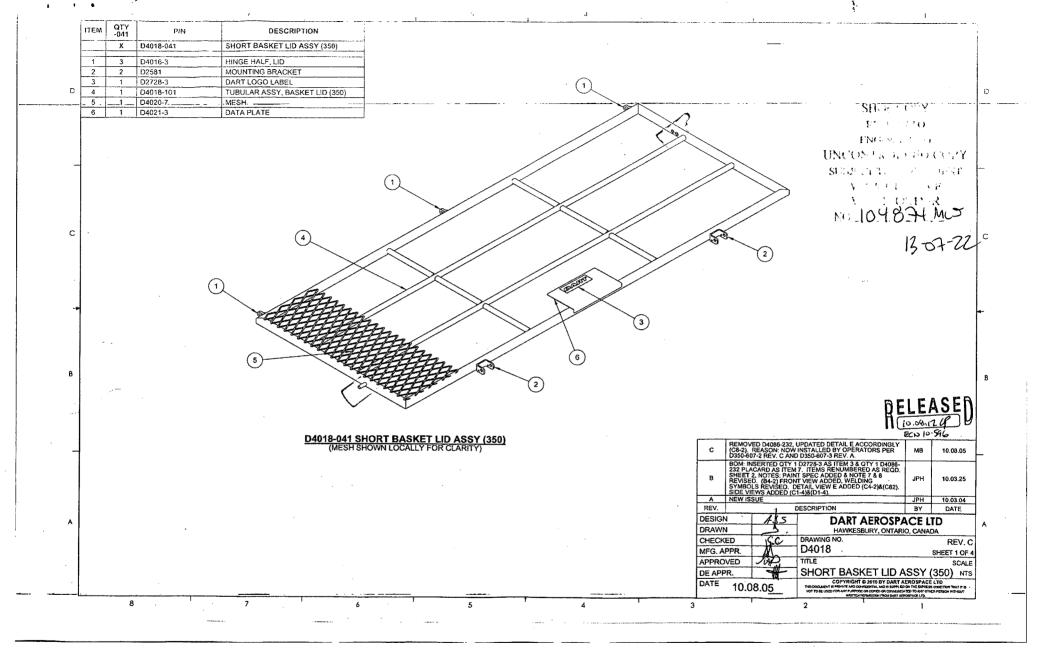
Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

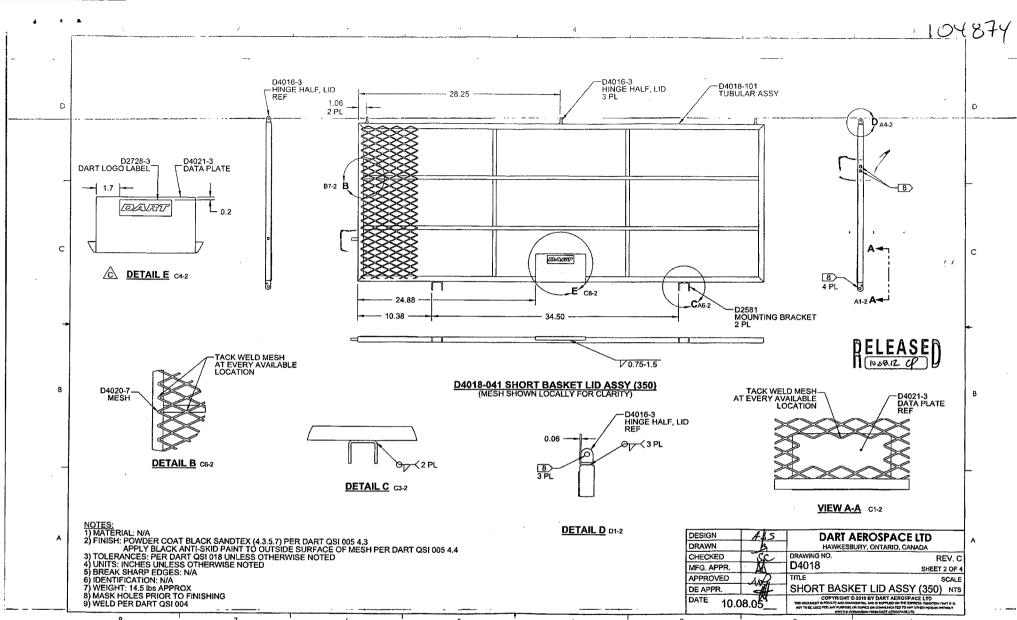
Finish Folio



DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Engineering Skid-tube Crosstube Water Jet Rework Quality Machining Prod. Eng. Coor. Part No. Small Fab Scrap Thermoforming Finishing Rec/Store/Packaging Other Use-as-is Supplier NCR No. Work Order Update Large Fab Composite Description of work order update Action Sign & Initial Root Chief Eng Verification QC Inspector or Non-conformance Description Date Date Step Qtv Cause Doc/Data Equip/Tooling Operator Material Setup Other

Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Ovalized Bending Bend Grain BOM/Route Temperature/Cure Centre Not Concentric to O/S Hardware Over/Under tolerance Broken/Damaged Weld Inspection Incomplete Part Incorrect Cracks Wrong Stock Pulled Crushed/Crimped Instructions Incomplete/Unclear Part Lost/Missing Burrs Cuffs Contamination Maintenance Part Moved Positioned Wrong Heat Treat Countersink Mislabeled Other Inspection Strip in Tube Misread Power Loss/Surge Cut Too Short **Drill Holes** Offset Ripples in Bend Out of Calibration Drawing Torque Waves in Extrusion Out of Sequence Finish Turning Sequence Wave/Twist in Tube Folio **Outside Dimensions** 

Process Supplier Training



3

. 2

											DQA:	Da	ite:	
NCR: Y	es / No				WORK ORDER NON-C	100	NFORM	MANCE / UP	DATE		QA Closed:		ate:	
					DISPOSITION				AGAINST D		PARTMENT		ic.	
Work Orde	er:					.			_	_	,,		_	1 $\square$
Part N					Rework Scrap Use-as-is		Thern	Skid-tube Machining noforming	Crosstube Small Fab Finishing			Water Jet d. Eng. Coor e/Packaging		Engineering Quality Other
NCR N	lo			·	Work Order Update	j		Large Fab	Composite	╝		Supplier	`	
Root				Descri	ption of work order update		nitial	Ac	tion		Sign &			
Cause	Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	n	QC Inspector
Doc/Data											4			
Equip/Tooling														
Operator														
Material														
Setup														
Other														
Process	_													
Supplier														
Training	$\vdash$													
Unapproved		<b>.</b>	<u> </u>	<u></u> .	F	<u>L</u> Διπ	T CATE	GORY			<u> </u>			I
Landii	ng Gear				General									
	Bending	<u>ı</u>			Bend	Г	Grain		Г		Ovalized		Г	Pressure/Forced
		, Not Conce	ntric to	o/s	BOM/Route	T	Hardwa	re	<u> </u>		Over/Under	tolerance		Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorred	at		Weld
	Crushe	d/Crimped			Burrs		Instruct	ions Incomplete/	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
	Cuffs	•			Contamination		Mainte	enance	Γ		Part Moved			-
	Heat Tr	eat			Countersink		Mislabe	eled			Positioned W	Vrong		_
	Inspect	ion Strip ir	n Tube		Cut Too Short		Misread	d			Power Loss/:	Surge		Other
	Ripples	in Bend			Drill Holes		Offset				·			

Out of Calibration

Out of Sequence

Outside Dimensions

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Turning Sequence

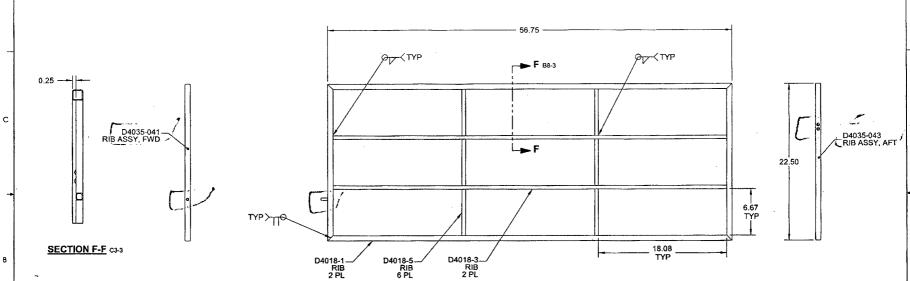
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio



8 D4018-101 TUBULAR ASSY, BASKET LID (350)

N	QIES:
- 1	MATERIAL: N/A
	FINISH: NONE
	TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4	UNITS: INCHES UNLESS OTHERWISE NOTED
5	BREAK SHARP EDGES: N/A
6	DENTIFICATION: N/A
7	WEIGHT: 9.06 lbs
8	TOLERANCE FOR XX.XX DIMENSIONS ±0.06 FOR D4018-101
9	WELD PER DART QSI 004

ITEM QTY

X

2

6

2

3

4

D4018-101

D4018-1

D4018-3

D4018-5

 DESCRIPTION
TUBULAR ASSY, BASKET LID (350)

BASKET LID RIB ASSY, FWD

BASKET-LID RIB ASSY, AFT

RIB

RIB

RIB

DESIGN	415	DART AEROSPACE LTD						
DRAWN	1	HAWKESBURY, ONTARIO, CANADA						
CHECKED	Se	DRAWING NO. REV. C						
MFG. APPR.	MA.	D4018 SHEET 3 OF 4						
APPROVED	NW	TITLE SCALE						
DE APPR.	4	SHORT BASKET LID ASSY (350) NTS						
DATE 10.0	08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IN PRANT AND COMPOSITION AS IN SPIRED ON THE COPYRISE CONCIDENT THAT IT IS NOT TO BE USED FOR ANY PLAPFACE ON CONFICE ON COMMUNICATED ANY OTHER PRISON WITHOUT RECTTOR FOR DESCRIPTION FROM DUST ARROBOTH ACT TO						

DQA: Date:

**WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Crosstube Water Jet Engineering Skid-tube Rework Quality Small Fab Prod. Eng. Coor. Part No. Machining Scrap Other Thermoforming Finishing Rec/Store/Packaging Use-as-is Supplier Work Order Update Large Fab Composite NCR No. Description of work order update Initial Action Sign & Root or Non-conformance Chief Eng Description Date Verification QC Inspector **∂Date** Step Qty Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Ovalized Bending Bend Grain Temperature/Cure BOM/Route Over/Under tolerance Centre Not Concentric to O/S Hardware Broken/Damaged Inspection Incomplete Part Incorrect Weld Cracks Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped Burrs Maintenance Part Moved Cuffs Contamination Mislabeled **Positioned Wrong** Heat Treat Countersink Power Loss/Surge Other Cut Too Short Misread Inspection Strip in Tube **Drill Holes** Offset Ripples in Bend

**Out of Calibration** 

Out of Sequence

**Outside Dimensions** 

**Turning Sequence** 

Wave/Twist in Tube

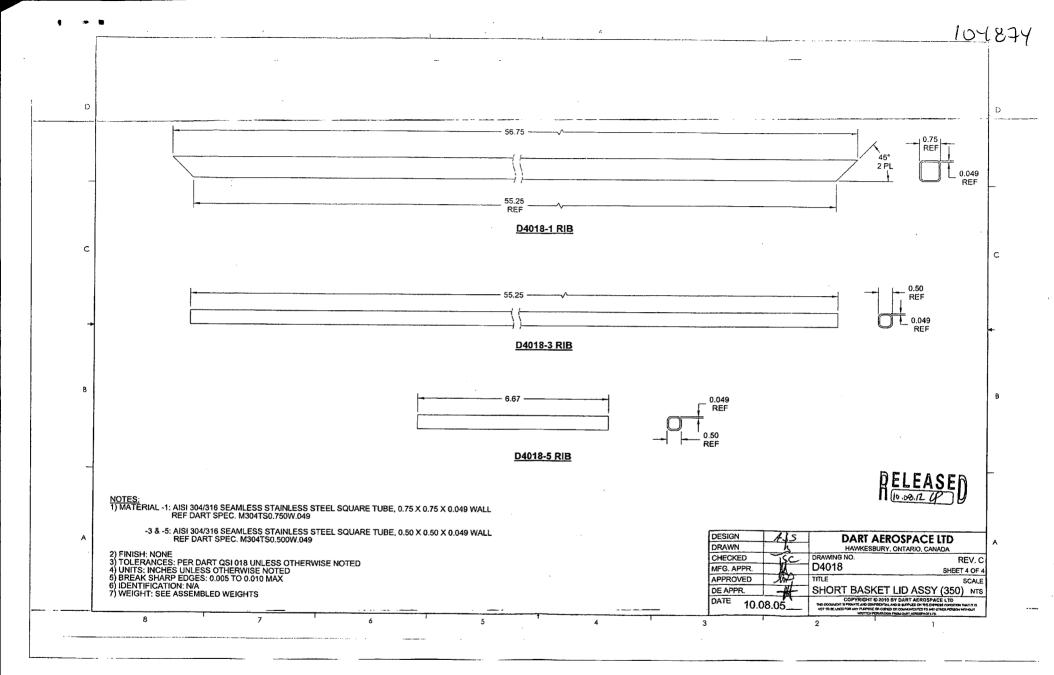
Torque Waves in Extrusion

Drawing

Finish

Folio

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DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** Engineering Skid-tube Crosstube Water Jet Small Fab Prod. Eng. Coor. Quality Machining Rec/Store/Packaging Other Thermoforming Finishing Work Order Update Composite Supplier Large Fab Description of work order update Action Sign & Initial Chief Eng Description Date Verification QC Inspector

Unapproved **FAULT CATEGORY Landing Gear** General Ovalized Pressure/Forced Bend Grain Bending Centre Not Concentric to O/S BOM/Route Temperature/Cure Over/Under tolerance Hardware Broken/Damaged Part Incorrect Weld Cracks Inspection Incomplete Crushed/Crimped Part Lost/Missing Wrong Stock Pulled Burrs Instructions Incomplete/Unclear Cuffs Contamination Maintenance Part Moved Positioned Wrong **Heat Treat** Countersink Mislabeled Power Loss/Surge Other Inspection Strip in Tube **Cut Too Short** Misread Ripples in Bend **Drill Holes** Offset **Torque Waves in Extrusion** Drawing Out of Calibration Turning Sequence Finish Out of Sequence Folio Wave/Twist in Tube **Outside Dimensions** 

DISPOSITION

or Non-conformance

Rework

Use-as-is

Scrap

Yes / No

Work Order:

NCR No.

Root

Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training

Part No.

Date

Step

Qty

NCR:

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